

# Work Order ID 60320

July 5, 2010 10:32:34 AM



Page 1

Item ID: D2327-3

Revision ID:

Item Name: Spacer Bushing

Start Date: 7/05/10 Start Qty: 20.00

Required Date: 7/09/10 Req'd Qty: 20.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals: Process Plan: *CL*

Date: 10/7/05 Tooling:

QC:

Date: SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2327

Rev D

100



Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

0.00

Memo

0.00

Turn per Folio FA232 and Dwg D2327 ☐ Debur

*SA 10/07/14*

*20* *Ø*

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIR

0.00

Memo

0.00

*SA 10/07/14*

*20* *Ø*

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

*SA 10/07/15*

*20* *Ø*

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 60320

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Item ID: D2327-3

Revision ID:

Item Name: Spacer Bushing

Start Date: 7/05/10

Required Date: 7/09/10

Reference:

Start Qty: 20.00

Req'd Qty: 20.00

Accept

Cust Item ID:  
Customer:

Setup Start  
Stop

Run Start  
Stop

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Sequence ID/  
Work Center ID

130



Packaging

Packaging

Operation  
Description

Identify as per dwg & Stock Location:

*Basket cell*

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

*10/07/16*

*20x*

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

*10-7-16*

*10-7-16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

July 5, 2010 10:32:34 AM

Work Order ID: 60320

Parent Item: D2327-3

Parent Item Name: Spacer Bushing



Page 1

Start Date: 7/05/10

Start Qty: 20.00

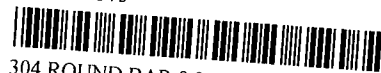
Required Date: 7/09/10

Required Qty: 20.00

Comments:

IPP F 05.11.02 Removed 303 SS KJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	19.9400	0.1563	3.290526			
304 ROUND BAR 0.375													



Location

MAT

111323

114467

114676

MAT029

113325

114356

Loc Qty

14.6

0

5.1

9.5

5.34

3.85

1.49

Loc Code

115180

3.2 AT 8/10/07/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

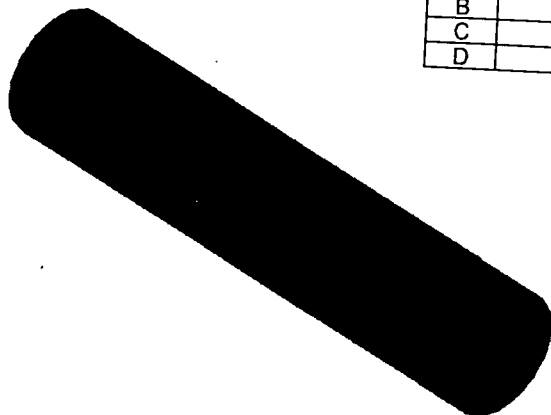
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

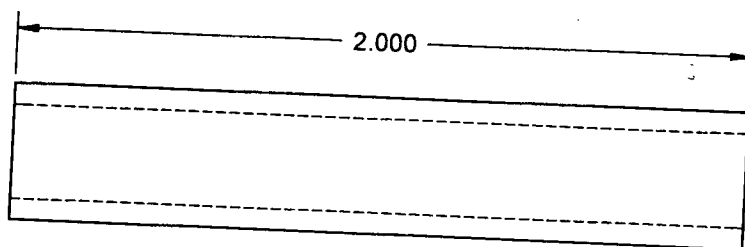


DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>CH</b>	DRAWING NO. <b>D2327</b>	REV. D SHEET 1 OF 1
DATE <b>06.10.12</b>		TITLE <b>SPACER BUSHING</b> SCALE 2:1	
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	

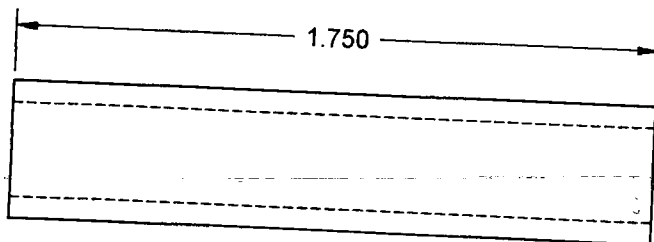
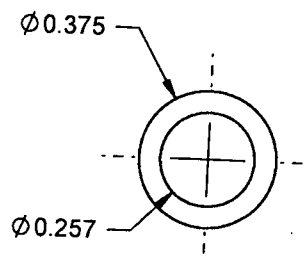


RELEASED

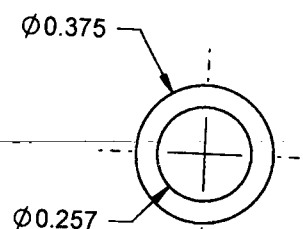
06.11.14



**D2327-1 SPACER BUSHING**



**D2327-3 SPACER BUSHING**



c210/7105

W10.60320

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS,  $\phi 0.375$ , 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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